

Date: Tuesday, 08/07/2008 1:46:53 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT GUIDE PLATE
 Job Number : 40372
 Estimate Number : 13364
 P.O. Number :
 This Issue : 08/07/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D35897
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3589 REV B PRELIM 08.06.26
 Previous Run : 05027 Drawing Revision : B PRELIM
 Material :
 Due Date : 15/07/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A 08-06-05 new issue DD verified by: ec

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.0650 sf(s)/Unit Total: 0.0650 sf(s)

304/316 .063 Sheet

batch: 108090

ml 08 07 09

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3589

Dwg Rev: B prel

Prog Rev: B prel

ml 08 07 09

(1)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 08 07 09



(1)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



ENGINEERING APPROVAL



Comment: SECOND CHECK

has.201 08/07/09 @

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1- Bend as per Dwg D3589

SB 08/07/09

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 1:46:53 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT GUIDE PLATE

Job Number: 40372

Part Number: D35897

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/08 @

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

USED ON D3589-041

B/N: B40366

08/07/08

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



08/07/21

POSITIVE RECALL

EFFECTIVE

08-07-21

AUTH

DATE

RELEASED

POSITIVE RECALL

EFFECTIVE

08-07-08

AUTH

12

RELEASED

08-07-21

DATE

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

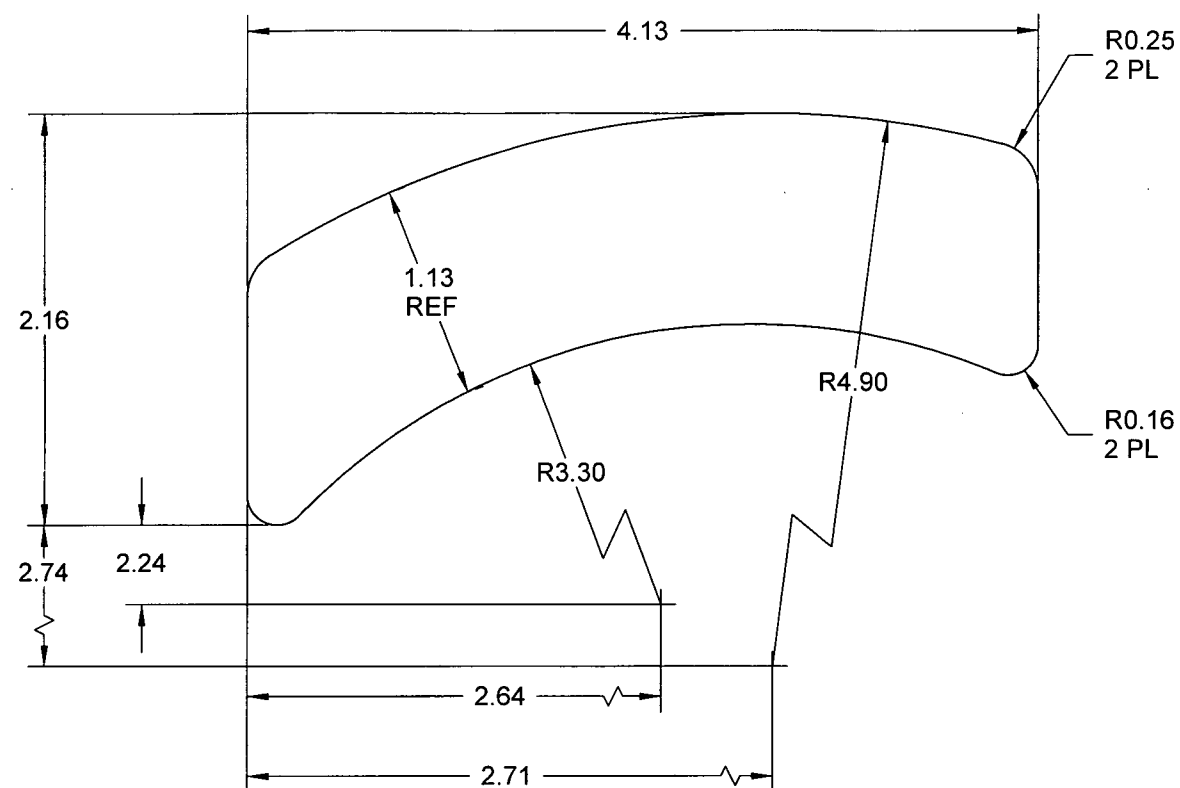
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

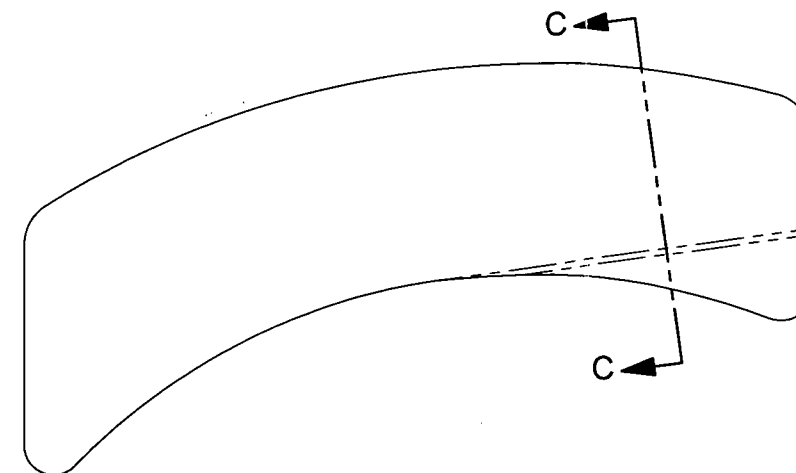
NOTE: Date & initial all entries

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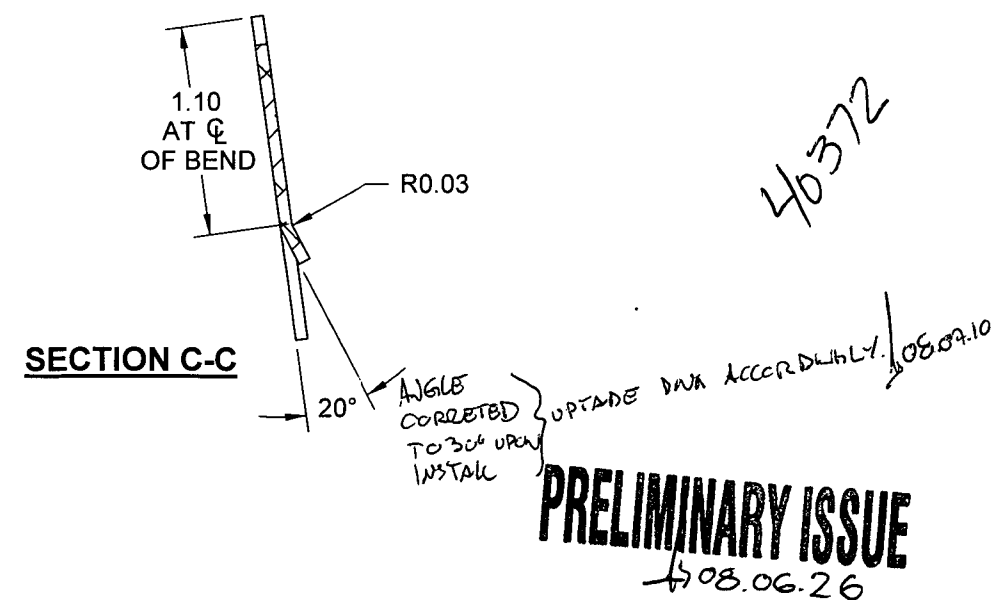
D
C
B
A



**D3589-7F AFT GUIDE PLATE
FLAT PATTERN**



D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F



- D3589-7/-7F NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.09 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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 Estimate Number : 13364
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 Previous Run : 05027 Project Number : N/A
 Material :
 Due Date : 15/07/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A 08-06-05 new issue DD verified by: ec

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



6375



Comment: Qty.: 0.0650 sf(s)/Unit Total: 0.0650 sf(s)
 304/316 .063 Sheet
 batch: 108098 ml 08 07 09

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3589
 Dwg Rev: B prel
 Prog Rev: B prel
 2-Deburr if necessary

ml 08 07 09

(1)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 08 07 09



(1)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



ENGINEERING APPROVAL



Comment: SECOND CHECK

108098 08/07/09

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 1- Bend as per Dwg D3589

SB 08/07/09

(1)

Dart Aerospace Ltd

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Receiving Slip

Date May 22, 2008	Page 1
Receipt Number RCP00007949	

REFERENCE ONLY

Purchase From:

Campi Steel
935 Boul. Du Havre
Valleyfield, QC J6S 5L1

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-CAM002	PO00006375

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M1010B0750X025	ASTM A21 Steel .75"x	40.0000	f	6.250000	250.00	May 22, 2008
		OR CSA G40-21, 38W/44W/50W/60W/70W					
		MATERIAL: AISI 1010-1025 OR ASTM					
		A36/A366/A569/A570					
		B/N108090					
	M2024T3R1250	2024-T3 Round Bar 1.2	12.0000	f	10.950000	131.40	May 22, 2008
		PER AMS-QQ-A-200/B OR AMS 4152/4164/4165					
		MATERIAL: 2024-T3 OR T3510/T3511 ALUMINUM					
		ROUND BATR					
		B/N108090					
	M2024T3S040	2024-T3 .040 sheet	96.0000	sf	8.750000	840.00	May 22, 2008
		PER QQ-A-250/4 OR AMS 4037					
		MATERIAL: 2024-T3 ALUMINUM SHEET					
		B/N108090					
	M2024T3S063	2024-T3 .063 sheet	96.0000	sf	14.150000	1,358.40	May 22, 2008
		AS ABOVE					
		B/N108090					
	M304S16GA	304/316 .063 Sheet	96.0000	sf	9.260000	883.20	May 22, 2008
		PER MIL-S-5019 ANNEALED 2B FINISH					
		MATERIAL: AISI 304/316 SS SHEET					
		B/N108090					
	M6061T6TS1250W	6061T6 SQ TUBE 1.25	20.0000	f	2.250000	45.00	May 22, 2008
		PER AMS-QQ-A-200/8 OR AMS 4150					
		PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR					
		SQUARE TUBING					
		MATERIAL: 6061-T6 OR 6061-R651/T6510/T6511/T62					
		B/N108090					

REFERENCE ONLY

REFERENCE ONLY

Comments:

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ART 159

THEE NAVY CORP.

IN THE UNITED STATES DISTRICT COURT OF THE DISTRICT OF COLUMBIA

ALICE BOY ABTIN A2001420

14517. 14240. 1430

WILL TEST CERTIFICATE

ORIGINAL

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MEMORANDUM FOR THE RECORD

General Remarks

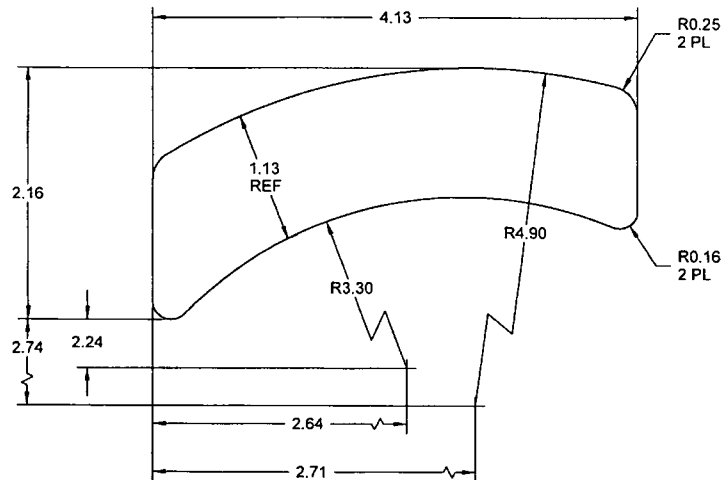
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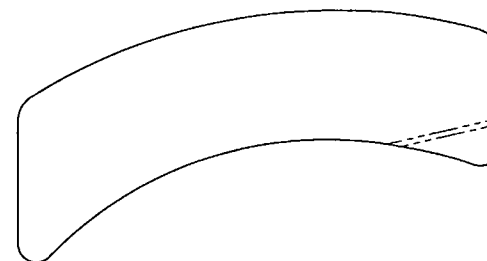
MDL

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[illegible]



**D3589-7F AFT GUIDE PLATE
FLAT PATTERN**



D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F

RELEASED
09/24/05

D3589-7F-7F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

40372

DESIGN	JH	DART AEROSPACE LTD	
DRAWN	JH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JH	DRAWING NO.	REV. B
MFG. APPR.	JH	D3589	SHEET 5 OF 8
APPROVED	JH	TITLE	SCALE
DE APPR.	JH	LATCH ASSEMBLY	NTS
DATE	08.06.25	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	